

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008553**Date Inspected:** 22-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#11

Magnetic Particle Inspection

This Q.A Inspector performed 100% Visual inspection and approximately 15% Magnetic Particle Testing of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the East tower lift 2 the welds Designation are as follows.

ESD1-TL7B/L-15, 16, 17; ESD1-TL7D/L-39, 40; ESD1-TL7K/L-17, 52, 15, 53, 16, 54; ESD1TL7C/L-166, 167, 59, 60

This QA Inspector randomly observed the following work in progress

BAY#11

FCAW welding process of weld joint 54 located on PCMK ESTC3-4G/K. Welder is identified as 066398 ZPMC QC is identified as Cao cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132

WELDING INSPECTION REPORT

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BAY#10

FCAW welding process of weld joint 43 located on PCMK NSD1FCSA3-1BC. Welder is identified as 048784 ZPMC QC is identified as Wang hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 13 located on PCMK NSD1-TL8D/L. Welder is identified as 057280 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW welding process of weld joint 115 located on PCMK NSD1TL8C/L. Welder is identified as 068864 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F

FCAW welding process of weld joint 29 located on PCMK EP1-A27A/E. Welder is identified as 069469 ZPMC QC is identified as Jun Jian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

FCAW welding process of weld joint 30 located on PCMK EP1-A27A/E. Welder is identified as 069095 ZPMC QC is identified as Jun Jian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

FCAW welding process of weld joint 35 located on PCMK EP1-A27A/E. Welder is identified as 068206 ZPMC QC is identified as Jun Jian Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer